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D4434-1

Job Sheet 188182



Part No: D4434-1

Job Qty: 12 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 2/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4434 REV C IPP REV:A 13.04.01 AS PER D4434 REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		1/14/19	0.00	1.36	Waterjet - Flow		2/19/03/08 DAS
120	QC	12 pcs		1/14/19	0.00	0.00	QC8		MAR 11 2019 40
130	Brake NC	12 pcs		1/14/19	0.04	1.36	Brake NC 2		2/28/03/08 DAS 9/28/19
150	QC	12 pcs		1/14/19	0.00	0.00	QC5		MAR 11 2019 36 40
160	HandFinish	12 pcs		1/14/19	0.00	1.41	HandFinish1		D.R. 19/03/19 DAS
170	QC	12 pcs		1/14/19	0.00	0.00	QC7-3		MAR 11 2019 40
180	Packaging	12 pcs		1/14/19	0.00	0.00	Packaging3-2	STCLY	MAR 19 2019 0-33
190	QC21-SA	12 Ea		1/14/19	0.00	0.00	QC21		MAR 20 2019

Part Op 100 - 1-Cut D4434-1 as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 130 - 1-C'sink as per dwg.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	18.7920 sf (1.566 ea)	100-Waterjet - Flow - 1	S152150

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	19	11	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.098Inches + 0.004 - 0.001	0.102 0.097	Diameter	
2	Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176	Diameter	
3	Bracket	0.468Inches ± 0.010	0.478 0.458		
4	Bracket	0.234Inches ± 0.010	0.244 0.224		
5	Bracket	0.670Inches ± 0.030	0.700 0.640		
6	Bracket	3.880Inches ± 0.030	3.910		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

7	Bracket	10.260Inches ± 0.030	3.850 10.290 10.230
8	Bracket	2.527Inches ± 0.010	2.537 2.517
9	Bracket	10.390Inches ± 0.030	10.420 10.360
10	Bracket	2.020Inches ± 0.030	2.050 1.990
11	Bracket	2.470Inches ± 0.030	2.500 2.440
12	Bracket	2.720Inches ± 0.030	2.750 2.690
13	Bracket	4.270Inches ± 0.030	4.300 4.240
14	Bracket	22.200Inches ± 0.030	22.230 22.170

Plex 1/4/19 10:31 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



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Date : _____	Sequence #: _____				MRB (QSI042)
Descr					Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Surge ☐ m ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:					